Work Order ID 124431

September-11-14 12:05:39 PM

124431

Item ID: D4761-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Shim Block **Stop** *NS2*

Start Date: 9/10/14 **Start Qty:** 20.00 *20*

Required Date: 9/10/14 **Req'd Qty:** 20.00 *20*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLJ **Date:** 14-09-17 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D4761 / A									
120	Cut blanks as per folio	0.00							
120 Bandsaw Jeaspa Bandsaw	**Memo**	0.00				20	0		J.C.L. 14/10/07
130	Manufacture as per dwg	0.00							
130 Mill Conv Conventional Milling Machine	**Memo**	0.00				20	0		J.C.L. 14/10/07
140	QC2- Inspect parts off machine FAI/FAIB	0.00							
140 QC Quality Control	**Memo**	0.00				20	0		J.C.L. 14/10/07

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 124431

September-11-14 12:05:39 PM

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Item ID: D4761-1 **Accept** *N900040100* **Setup Start** *NS1*

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Item Name: Shim Block **Stop** *NS2*

Start Date: 9/10/14 **Start Qty:** 20.00 *20*

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Reference:

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Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							DAS 44 9-89
150						20	ø		14/10/08
QC	**Memo**	0.00							
Quality Control									
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160						20	ø	14-10-9	
HandFinish	**Memo**	0.00							
Hand Finishing									
170	QC7-Inspect Chemical Conversion Coat	0.00							DAS 38 9-89
170						20			14-10-9
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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- ☐ Heat Treat
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- ☐ Mislabeled
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- ☐ Out of Sequence
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- ☐ Part Incorrect
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- ☐ Other

Item ID: D4761-1 **Accept** *N900040100* **Setup Start** *NS1*
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Item Name: Shim Block
Start Date: 9/10/14 **Start Qty:** 20.00 *20*
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Reference: **Cust Item ID:** **Customer:**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: S1/20	0.00							
180						20	DAS 06 9-89	OCT 09 2014	
Packaging	**Memo**	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190							14/10/10		
QC	**Memo**	0.00							
Quality Control									

MF 14-10-10

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Material	☐									
Operator	☐									
Offset/Setup	☐									
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Supplier	☐									
Training	☐									
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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Picklist Print

September-11-14 12:05:39 PM

Work Order ID: 124431

124431

Parent Item: D4761-1

D4761-1

Parent Item Name: Shim Block

Start Date: 9/10/14 **Required Date:** 9/10/14

Start Qty: 20.00 **Required Qty:** 20.00

Comments: IPP REV:A 13.02.19 AS PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X02.000		Purchased	No				f	32.7917		7			

M6061T6B0.500X02.000

6061-T6 Bar .500 x 2.00

**

J.C.L.

Location	Loc Qty	Loc Code	
MAT001	32.7917		
124573	14		3.4
M126160	2.0917		
M127464	4.7		3.75
M129375	12		

14/10/01

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

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Material	☐									
Operator	☐									
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Process	☐									
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

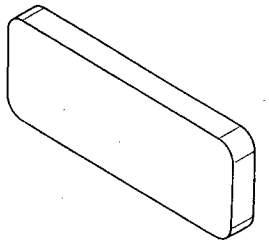
DART AEROSPACE LTD	Work Order:	124431
Description: Shim Block	Part Number:	D4761-1
Inspection Dwg: D4761 **Rev:** A		Page 1 of 1

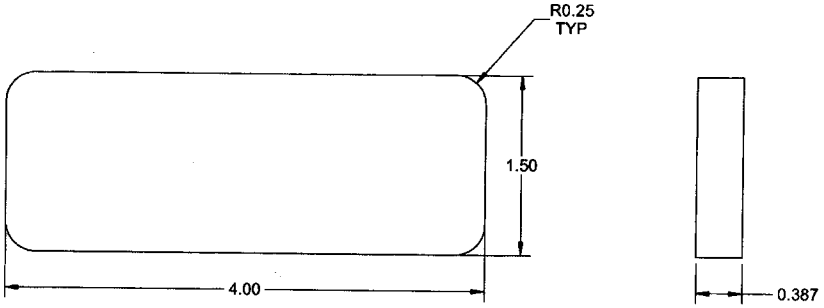
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.50	+/-0.030	1.500	✓		Caliper	SCL-08
4.00	+/-0.030	4.001	✓		"	
0.387	+/-0.010	0.387	✓		Micrometer	SCL-01
R0.25	+/-0.030	0.250	✓		Rad Gauge	
			DAS			

Measured by:	J.C. Lloyd	Audited by:	~~44~~ 9-89	Preliminary Approval:	
Date:	14/10/08	Date:	14/10/08	Date:	

Rev	Date	Change	Revised by	Approved
A	13.07.10	New Issue	KJ	





SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 124431 MLS
1409-17

D4761-1 SHIM BLOCK

RELEASED
2013 -02- 14

NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC. M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.21 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	RF	13.01.08

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA
DRAWN	RF	
CHECKED		DRAWING NO. D4761 REV. A
MFG. APPR.		SHEET 1 OF 1
APPROVED		TITLE SHIM BLOCK SCALE NTS
DE APPR.		
DATE	13.01.08	

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